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Work Order ID 155173

155173

Page 1

Monday, January 09, 2017 3:53:53 PM

Item ID: D4775-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Strut Assembly

Start Date: 1/9/2017 Start Qty: 2.00 ** Cust Item ID:

Required Date: 1/11/2017 Req'd Qty: 2.00 ** Customer:

Reference:

Approvals: Process Plan:  Date: JAN 09 2017 Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4775	C

110	Pick Kit	0.00							
110	Large Fab								
Packaging	Memo	0.00							
Packaging									

2 JAN 10 2017 DAS 6 9-80

120		0.00							
120									
Small Fab	Memo	0.06							
Small Fab									

2 FF JAN 10 2017

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: 136076

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																					
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Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly
Start Date: 1/9/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 1/11/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				2			DAS 38 JAN 11 2017
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>301d</i> Memo	0.00 0.00				2 DAS 6 9-89			JAN 11 2017
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.03							DAS 21 9-89 JAN 16 2017 <i>mk</i> 17-1-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Work Order ID: 155173

155173

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 1/9/2017

Required Date: 1/11/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP
REV:B 13.08.26 PB1 DD VERF:JLM IPP REV:C
13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10
AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4775-1		Manufactured	No			110	Each	18.0000	1	2			
D4775-1									**				
Strut Tube													

Location	Loc Qty	Loc Code
ST357	18	
151807	8	
154191	10	

JAN 10 2017 9-89

D4777-1		Manufactured	No			110	Each	33.0000	1	2			
D4777-1									**				
Rod End Bearing													

Location	Loc Qty	Loc Code
ST125	33	
151608	3	
152027	10	
153285	10	
154431	10	

JAN 10 2017 9-89

D4776-1		Manufactured	No			110	Each	23.0000	1	2			
D4776-1									**				
Basket Strut Clevis													

Location	Loc Qty	Loc Code
ST124	23	
151738	3	
154152	20	

JAN 10 2017 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 155173

155173

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 1/9/2017

Required Date: 1/11/2017

Start Qty: 2.00

Required Qty: 2.00

D4776-5 Manufactured No

110 Each 65.0000 4 8

D4776-5

Spacer

JAN 10 2017 DAS 6 9-89

Location Loc Qty Loc Code

ST125	65	
151812	15	
152352	50	

AN3-10A Purchased No

110 Each 148.0000 2 4

AN3-10A

Bolt

JAN 10 2017 DAS 6 9-89

Location Loc Qty Loc Code

over003	100	
m136192	100	
ST349	48	
m135966	48	

MS21042L3 Purchased No

110 Each 1,699.000 2 4

MS21042L3

Nut

JAN 10 2017 DAS 6 9-89

Location Loc Qty Loc Code

FP001	100	
m135945	100	
GA	162	
m134360	108	
m135135	54	
ST303	1437	
M136044	337	
M136192	600	
M136406	500	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
DART				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 155173

155173

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 1/9/2017

Required Date: 1/11/2017

Start Qty: 2.00

Required Qty: 2.00

MS21209-F615

Purchased

No

110

Each

73.0000

1

2

MS21209-F615

FF

JAN 10 2017

Heli-Coil

Location

Loc Qty

Loc Code

GA

73

m135058

73

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

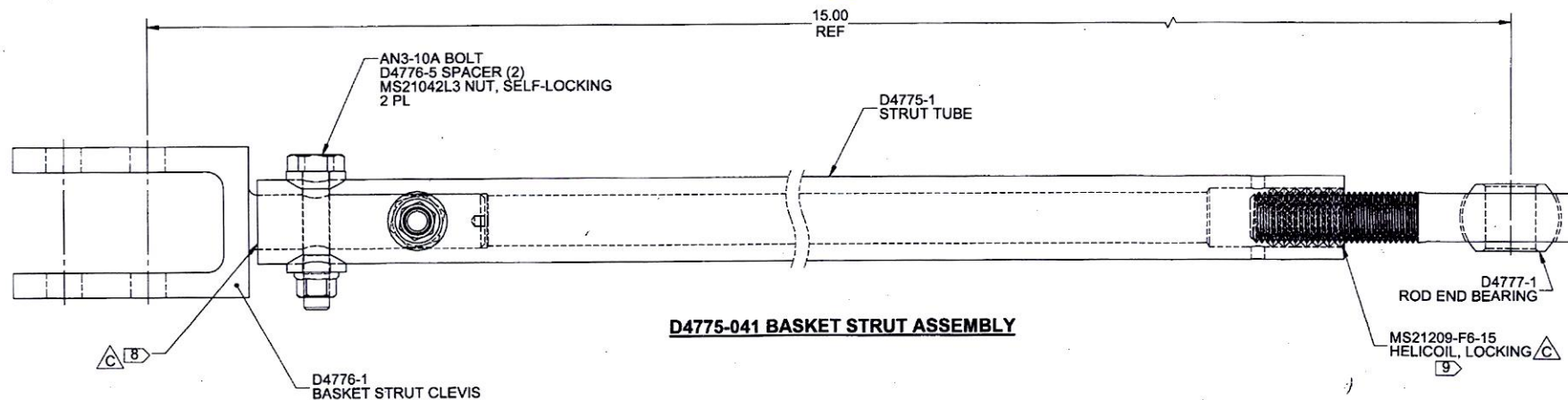
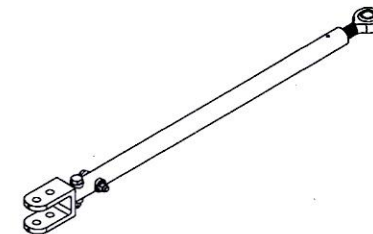
QA Closed: _____ Date: _____

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4775-041	BASKET STRUT ASSEMBLY
1	1	D4775-1	STRUT TUBE
2	1	D4776-1	BASKET STRUT CLEVIS
3	4	D4776-5	SPACER
4	1	D4777-1	ROD END BEARING
5	2	AN3-10A	BOLT
6	2	MS21042L3	NUT, SELF-LOCKING
7	1	MS21209-F6-15	HELICOIL, LOCKING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155173
JAN 09 2017



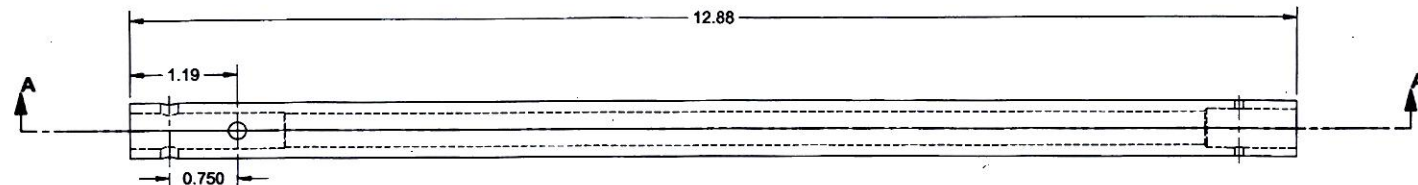
D4775-041 BASKET STRUT ASSEMBLY

NOTES:

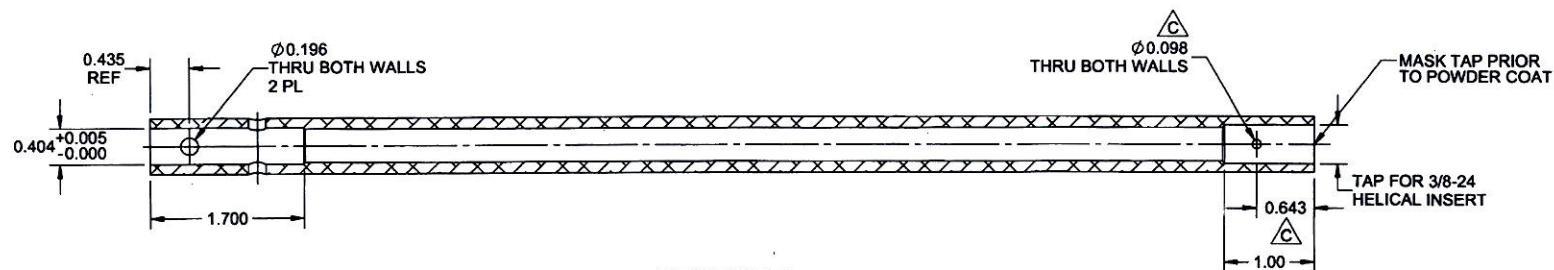
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.45 lbs
- 8) APPLY PROSEAL 890 B-2 (PRC) TO THE STEM OF ITEM 2 TO PREVENT RATTLING.
- 9) ENSURE HELICOIL DOES NOT BLOCK HOLE

RELEASED
2014-01-07

C	ITEM 7 WAS F6-20, B2-2 Ø0.098 "WITNESS HOLE" ADDED. REASON: CUSTOMER FEEDBACK, ADDED NOTE 8. REASON: DESIGN IMPROVEMENT.	AJS	13.11.01
B	DELETED WELD PINS (-3) REPLACED WITH FASTENERS. REASON: PREVENT CRACKING & EASE OF MANUFACTURE. C6-2 HOLE PATTERN ON -1 REVERSED TO ENSURE FASTENERS CLEAR STRUCTURE. FINISH NOTE MOVED TO -1 (SHEET 2).	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
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D4775-1 STRUT TUBE



SECTION A-A

RELEASED
2014-01-03

NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, $\phi 0.625 \times 0.125$ WALL PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 OR AMS 4080 OR AMS 4082 OR AMS 4083 OR ASTM B210 OR ASTM B241 REF DART SPEC M6061T6T0.625W0.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.R.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
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